



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3808-1

Job Sheet 191630



Part No: D3808-1

Job Qty: 10 pcs

Part Name: Seat Rail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/5/19

Job Tracking No:

Due Date: 3/18/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP Rev:A New Issue 08-07-31 JLM Verified By:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	10 pcs		3/18/19	0.00	0.02	Bandsaw - 1		marc 19/03/10
110	HAAS 4 Axis - B4B	10 pcs		3/18/19	0.29	15.38	HAAS - 1 - B4B		marc 19/03/14
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	10 pcs		3/18/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		marc 19/03/14
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 54		
							QC 2 - 56		



Container No: S160936



Part: D3808-1

Job No: 191630

Serial No/Batch: S160936

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/10/19

Plex 3/5/19 1:05 PM Dart.lajeunesse.marie

130 QC 8	10 pcs	3/18/19	0.00 0.00	QC 2 - 57	
				QC 2 - 62	
				QC 2 - 63	
				QC 2 - 8	
				QC 2 - 66	
				QC 2 - 64	
				QC 8 - 12	DmK 19/03/16
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
140 Handfinish - 1-1 Chemical-B4B	10 pcs	3/18/19	0.00 0.71	Handfinish - 1 - 1 - B4B	BEB 19-0320
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	

Plex 3/5/19 1:05 PM Dart.lajeunesse.marie

141 QC 7	10 pcs	3/18/19	0.00 0.00	Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
				QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 6	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
150 Packaging 3-1 - Stock - B4B	10 pcs	3/18/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	

DAS
40
9-89

MAR 20 2019

DAS
58 MAR 21 2019
9-89

				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
160 QC 21 - SA	10 pcs	3/18/19	0.00 0.00	QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21
				QC 21 - SA - 53	9-88

MAR 21 2019

Part Op 100 - (Bandsaw) Cut blank 16.125 " long
 Descriptions: 110 - (HAAS CNC Vertical Machine) 1- Mill as per Folio FA771 Rev: 4A & Dwg D3808 Rev: A 2-Tap holes for 8-32" Helicoil 3-Tap holes for 3/8-16 Helicoil 4-Deburr per dwg D3808
 120 - (QC2- Inspect parts off machine FAI/FAIB)
 130 - (QC8- Inspect parts - second check)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 141 - (QC7- Inspect Chemical Conversion Coat)
 150 - (Identify as per dwg & Stock Location: ST258)
 160 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B2.000X01.250	6061-T6 Bar 2.00 X 1.25	13.5000 ft (1.35 ea)	100-Bandsaw - 1	S12 79 79 x2 S036062 x8 2.891'

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M6061T6B2.000X01.250	14	14	0

Part Specifications

Specifications could not be found.

DART AEROSPACE LTD		Work Order: 191630
Description: Seat Rail		Part Number: D3808-1
Inspection Dwg: D3808	Rev: A	Page 1 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.000	+/-0.010	13.998	✓		Height	31006
7.30	+/-0.030	7.300	✓		"	
0.550	+/-0.010	.550	✓		vern	mm L-05
0.85	+/-0.030	.850	✓		↓	
0.780	+/-0.010	0.784	✓		↓	
Ø0.391	+0.006/-0.001	.392	✓		↓	
3/8-16 UNC	N/A	3/8-16	✓		TPG	
Ø0.323	+0.006/-0.001	.325	✓		vern	mm L-05
Ø0.695 x 100°	+/-0.010 x 0.5°	.695x100	✓		↓	
Ø0.172	+0.005/-0.001	.175	✓		↓	
8-32 UNC	N/A	8-32	✓		TPG	
0.800 x 0.667 deep	+/-0.010	.799x.677	✓		vern	mm L-05
2.00	+/-0.030	2.002	✓		"	
R0.26	+/-0.030	0.26	✓		RG	
6.13	+/-0.030	6.125	✓		vern	mm L-05
5.13	+/-0.030	5.125	✓		↓	
0.16	+/-0.030	.158	✓		↓	
1.75	+/-0.030	1.753	✓		↓	
15.88	+/-0.030	15.88	✓		Height	31006
0.965	+/-0.010	.965	✓		vern	mm L-05
0.375	+/-0.010	.373	✓		↓	
1.10	+/-0.030	1.101	✓		↓	
0.140	+/-0.010	.141	✓		↓	
0.373	+/-0.010	0.373	✓		↓	
0.030 x 45°	+/-0.010 x 0.5°	.035x45°	✓		↓	
R0.06	+/-0.030	.060	✓		RG	
0.347	+/-0.010	.350	✓		vern	mm L-05
0.270	+0.030/-0.000	.280	✓		↓	
Ø0.720	+0.005/-0.010	.721	✓		↓	
R0.063	+/-0.010	.063	✓		RG	
0.320	+0.020/-0.000	0.323	✓		vern	mm L-05
R0.015	+/-0.010	.015	✓		RG	
0.655	+0.015/-0.010	.655	✓		vern	mm L-05
0.350	+/-0.010	.353	✓		↓	
0.030 x 45°	+/-0.010 x 0.5°	0.038x45	✓		↓	
0.667	+/-0.010	.677	✓		↓	

DART AEROSPACE LTD		Work Order: 191630
Description: Seat Rail		Part Number: D3808-1
Inspection Dwg: D3808	Rev: A	Page 2 of 2

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.156	+/-0.010	.156	/		vern	mmL-05
Ø0.695	+0.008/-0.001	.695	/		↓	
Ø0.323	+0.006/-0.001	.325	/		↓	
Ø0.800	+0.010/-0.001	.799	/		↓	
R0.031	+/-0.010	.031	/		RG	

Measured by: mmL	Audited by: mk	Prototype Approval:	N/A
Date: 19/03/16	Date: 19/03/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	MS

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					